Work Ord <i>April-30-13 2:3</i>		1068		*101			Page 1				
Item ID: Revision ID: Item Name:	D3245-9 Gasket 8.35			Accept	*N900	040	100)* s	etup Star Sto	i V	S1* S2*
Start Date: Required Date: Reference:	4/30/13 : 4/30/13	Start Qty: 5.00 Req'd Qty: 5.00	• •		Cust Item I Customer:	D:					
Approvals:		an: MLS	Date: \\3005-0			ate:		R	un Stai Sto		R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3245	D	÷									
100		FLOW WATER JET		0.00				44	d		A lm
Waterjet FLOW CNC Water G-89	_{ijet} CloHh-	Dwg Re	per Dwg D3245 v:	0.00					Y -		13.06.10
*110		QC2- Inspect parts of	ff machine FAI/FAIB	0.00				44	لمد		4.19n
QC		Memo		0.00					Ψ		13.06.13

Quality Control

NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORN	MANCE / UPDATE				
											QA Closed:	Dat	te:
Work Orde	er:			·		DISPOSITION				_	PARTMENT,	/PROCESS Water Jet	¬ ⊏
Part No				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			ab ing	Pro Rec/Stor	Engineering Quality Other				
			· · · · · · · · · · · · · · · · · · ·	1									
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	l	nitial iief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/S	st ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
1	1	Ripples in Bend Drill Holes			1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 101068 April-30-13 2:39:30 PM			. ,	*101068*										
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D3245-9 Gasket 8.35 4/30/13 :: 4/30/13	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*	Accept			J900 Cust Item I		100)* s	Setup Sta	1 /	S1* S2*	
Approvals:	Process Pla	an:	Date:	Toolin				nte:	 	R	Run Sta Sto	" 7	R1* R2*	
Sequence ID/ Work Center I 120 *120* QC Quality Control	ID	Operation Description QC8- Inspect parts - seco	nd check	Set Rur 0.00	Up/ 1 Hours 13, (» 11	Tool ID	Tool #	Plan Code	Accept Qty UY COun	Reject Qty	Reject Number	Insp. Stamp	_
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Location: <u>5723</u> 2	0.00						44x		M.,	W. 13-0	6-11
*140 *14\n* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00						M	<u>ت</u>	13-0	0-12	12

												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE					
											_	QA Closed:	Da	ate:	
Work Ord	oŕ.					DISPOSITION				AGAINST D	Εf	PARTMENT	/PROCESS		
WOIK OIG	C1.					Rework	1		Skid-tube	Crosstube	٦	•	Water Jet	:[Engineering
Part I	No.					Scrap	1		Machining	Small Fab	٦	Pro	d. Eng. Coor	\vdash	Quality
						Use-as-is]	Therm	noforming	Finishing]	Rec/Stor	re/Packaging		Other
NCR I	Vo.		· · · · · ·			Work Order Update]		Large Fab	Composite	ل		Supplier		
Root					Descri	ption of work order update	П	Initial	Act	tion	7	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	╛	Date	Verification	n	QC Inspector
Doc/Data											ł				
Equip/Tooling											Ì				
Operator											ı				
Material					ļ						1				
Setup					1						İ				1
Other		İ													·
Process		}					ŀ				I				
Supplier	L.]									١				
Training	[1								I				
Unapproved							<u> </u>				╝				
							AUL	LT CATE	GORY		_		·		
Landi	ng (Gear				General	_	-		_	_				,
	L	Bending				Bend	L	Grain			╛	Ovalized		<u></u>	Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	<u>_</u>	╛	Over/Under	tolerance		Temperature/Cure
	L	Cracks				Broken/Damaged		Inspecti	ion Incomplete		╛	Part Incorred	ct .		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
1		Cuffs				Contamination	Maintenance					Part Moved			
		Heat Trea	at			Countersink	Mislabeled				Positioned W	/rong		_	
	Inspection Strip in Tube			Cut Too Short		Misread				Power Loss/S	Surge		Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-30-13 2:39:30 PM

Work Order ID:

101068

Parent Item:

D3245-9

Parent Item Name:

Gasket 8.35

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP B04.12.06Made in-houseKJ/JLM

IPP Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC IPP Rev:D 12.11.07 PER DWG

REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89 coated cloth		Purchased	No			100	sf .	68.7500	0.0406	0.213684		te,	Br
				Location		Loc Qty	<u>Lo</u>	c Code			13.	06.1	0
				MAT052 12399	93	68.75 4.5							
				12449	98	64.25			124	(498			

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UF	PDATE					· · ·
					=						_(QA Closed:	D	ate:	
Work Ord	or.					DISPOSITION				AGAINST DE	ΕP	PARTMENT	PROCESS		
WORK OIG	C1.					Rework	1		Skid-tube	Crosstube	٦		Water Je	t	Engineering
Part	No.					Scrap	1	3	Machining	Small Fab	1	Pro	d. Eng. Coor	_	Quality
						Use-as-is	1		noforming	Finishing	1		e/Packaging	-	Other
NCR I	No.					Work Order Update]	6	Large Fab	Composite			Supplie	- ┣━	
							_	L							
Root					B	ption of work order update	1	Initial	A	ction		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Des	cription	4	Date	Verification	on	QC Inspector
Doc/Data	<u> </u>														
Equip/Tooling	L										١				
Operator	_										1				
Material	L		•				ĺ				١				
Setup	<u> </u>		ļ		.						١				`
Other	L										1				
Process	L										1				
Supplier											1				
Training											1				
Unapproved		<u> </u>		i							丄				
						<u>F</u>	AUI	LT CATE	GORY						
Landi	ing (Gear				General	_	7			_				1
		Bending				Bend	\vdash	Grain		_	-	Ovalized		_	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		-	Over/Under		_	Temperature/Cure
	Cracks				Broken/Damaged		-1	on Incomplete		┥.	Part Incorrec			Weld	
	Crushed/Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	_ '	Part Lost/Mi	ssing		Wrong Stock Pulled		
		Cuffs .			L	Contamination		Mainte	nance		ا_	Part Moved			
	Heat Treat			Countersink		Mislabe	led		_]'	Positioned W	d Wrong				
1	Inspection Strip in Tube			Cut Too Short	Misread			-1	Power Loss/9	Surge	1	Other			

Offset

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Ripples in Bend

Torque Waves in Extrusion

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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

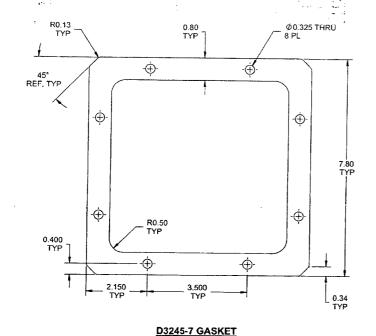
DART AEROSPACE L	TD		Work Order:	101068
Description: Gasket		Pl -	Part Number:	D3245-9
		PA -		
Inspection Dwg: D3245	Rev:	130402		Page 1 of 1

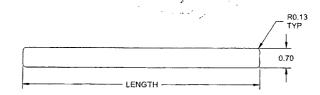
FIRST ARTICLE INSPECTION CHECKLIST

06

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
: 0.70	+/-0.030	0,70			V	DKm-01
8.35	+/-0.030	8.35	_		1	UKM-OI JER ZOI VKM
2.0350.060	+/-0.010	0.060	-		V	UKM-01
					· · · · · · · · · · · · · · · · · · ·	
						-9"
-					*.	
• •						
						-
			nA.			

Meas	ured by:	Ac In	Audited by:	27	Prelim	inary Approval:	
	Date:	13.06.10	Date:	13611		Date:	
Rev	Date	Change			1.	Revised by	Approved
A	07.11.23	New Issue				KJ/EC/DDI A	7/
В	12.06.19	Dimensions upda	ated per Dwg Rev	С		KJ P	





D3245-X GASKET

_	P/N	LENGTH
	D3245-9	8.35
_	D3245-11	9.01
	D3245-13	9.50

SHOP COPY A RIPNTO EN TWEERING UNCOMPROTIED AND A STRUCT LO AMENIMANT WITHOUT NO 101068 MCJ

13-05-01

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. D D3245 MFG. APPR. SHEET 7 OF 7 APPROVED TITLE DE APPR. ACCESS PANEL ASSY DATE 12.10.16

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NA
6) IDENTIFICATION: N/A
7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/-11/-13 = LESS THAN 0.01 lbs

D